

Work Order ID 55436

January 18, 2010 3:04:57 PM

HAI



Page 1

Item ID: D3822-2KIV

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, RH-Ivory

Start Date: 1/18/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

RP

Date: 10-1-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB
10/01/27
(X)

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA026 using tool DT9074
Dwg Rev: C
Folio Rev: A

BB
10/01/27
(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

B
10/01/27
(X1)

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

Dh. 10/01/27
(X1)

140

0.00

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

Dh. 10/01/27
(X1)

W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

OK 10/01/27
KT

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/12/28

tc

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

HAI

10-1-28

S/P 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 55436

Page 4

January 18, 2010 3:04:57 PM

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Item Name: Vertical Tunnel, RH-Ivory

Start Date: 1/18/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/2979
MF 10-1-28

00700JAN

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 18, 2010 3:05:02 PM

Page 1

Work Order ID: 55436



Parent Item: D3822-2KIV



Parent Item Name: Vertical Tunnel, RH-Ivory

Start Date: 1/18/10

Required Date: 1/22/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	790.9390	7.8039			



6185 KYDEX .080"

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	790.9390153	
109703	790.939015	

7.839 ft

BB
10/01/27
XI

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55436
Description: Vertical Tunnel, RH		Part Number:	D3822-2KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DL Date: 10/01/27

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.8	Min	1.091"	✓			
0.3	Min	0.330"	✓			
0.55	Min	0.747"	✓			
0.040	Min	0.046"	✓			
0.050	Min	0.063"	✓			

Measured by: DL Date: 10/01/27

Audited by: TD Date: 10/01/27

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

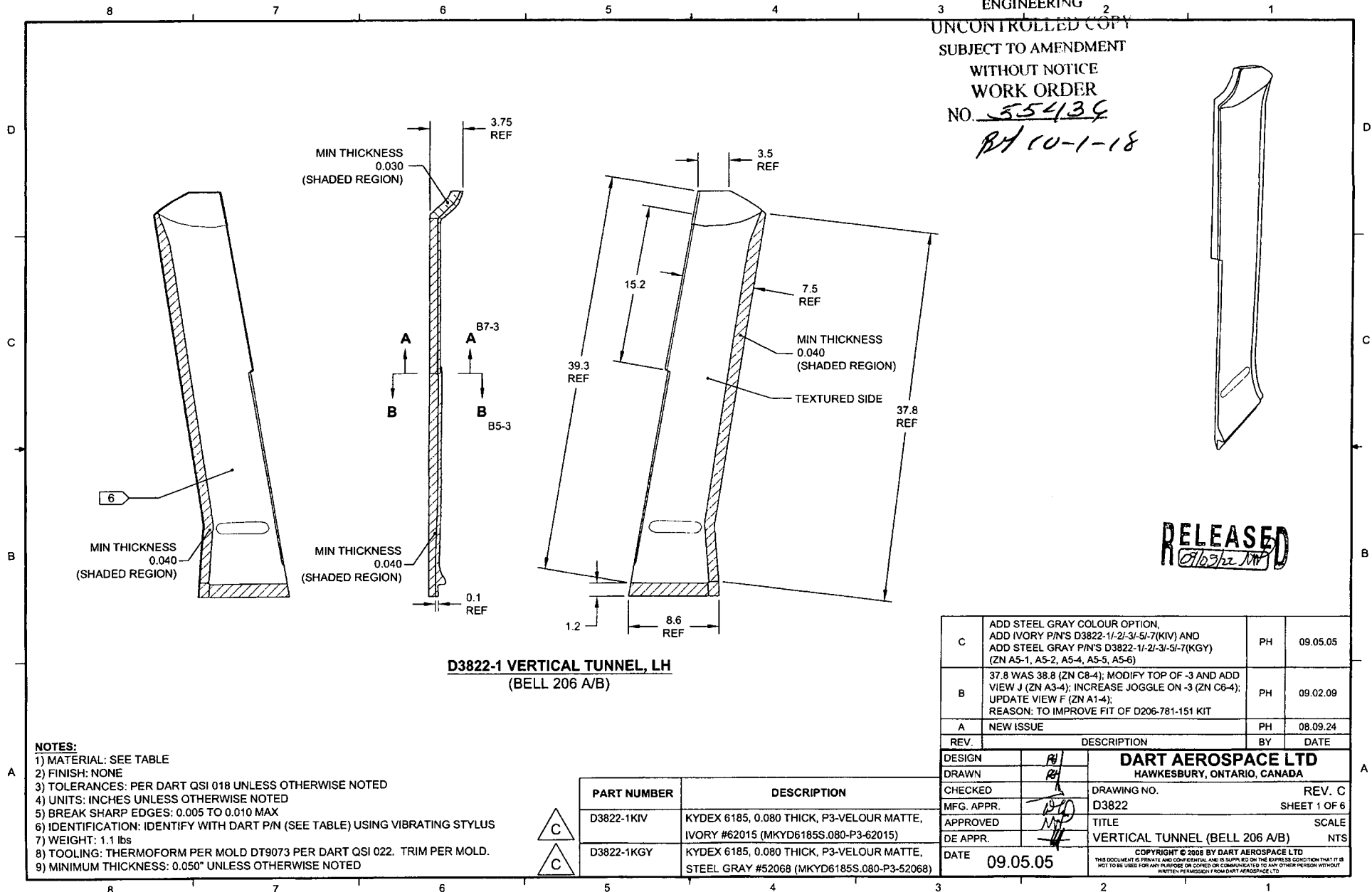
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 554134

RY 10-1-18



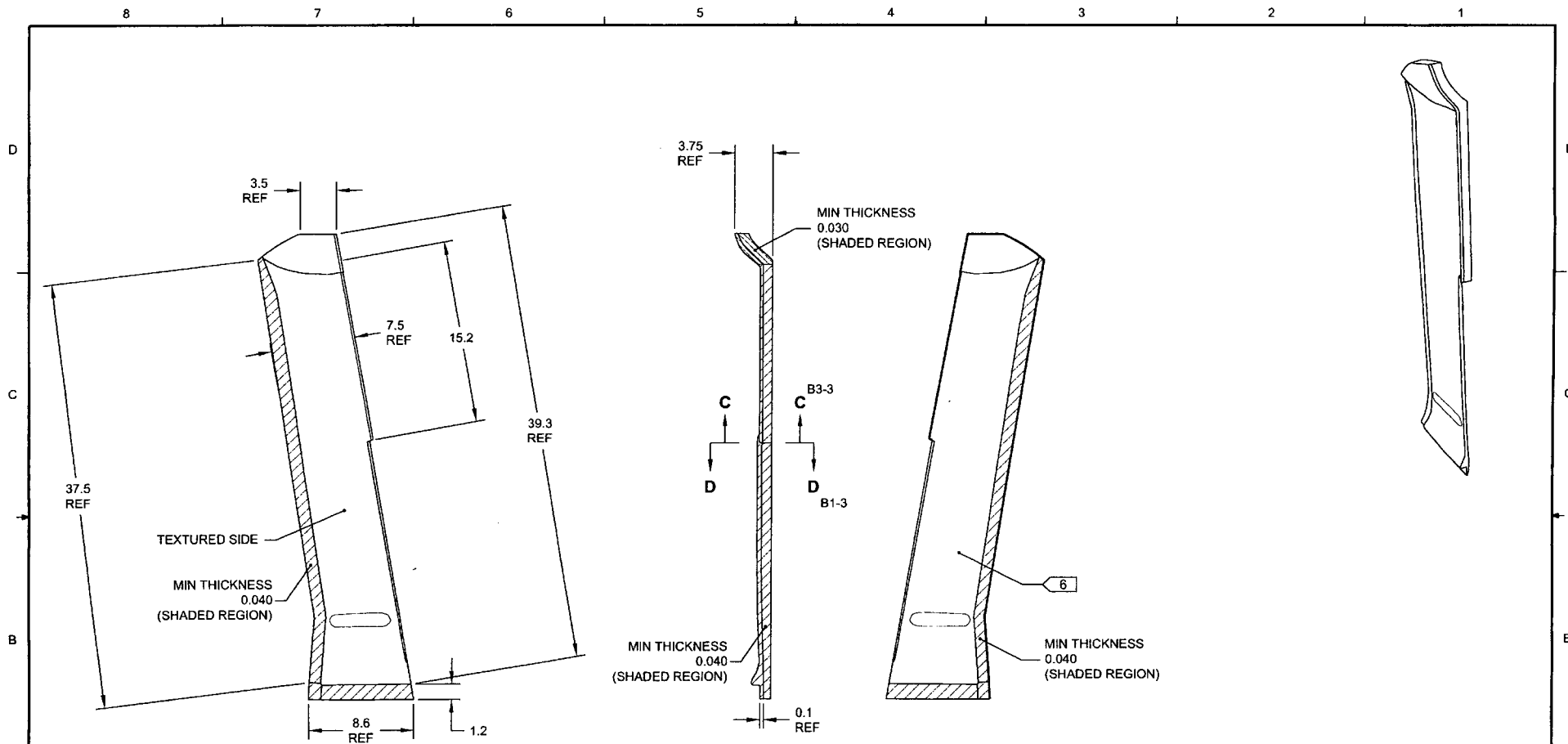
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3822-2 VERTICAL TUNNEL, RH
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9074 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION
D3822-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PAH	DART AEROSPACE LTD	
DRAWN	PAH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PAH	DRAWING NO.	REV. C
MFG. APPR.	PAH	D3822	SHEET 2 OF 6
APPROVED	PAH	TITLE	SCALE
DE APPR.	PAH	VERTICAL TUNNEL (BELL 206 A/B) NTS	
DATE	09.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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09/05/05

W10 55436

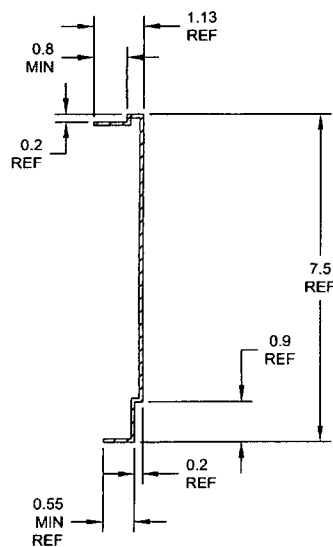
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

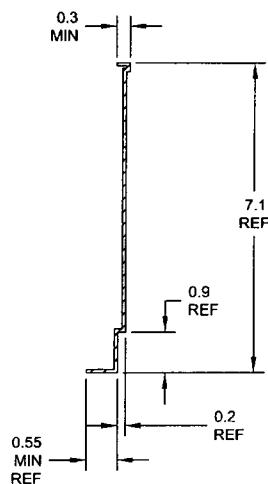
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

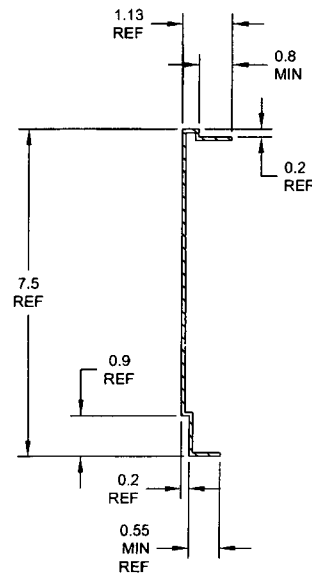
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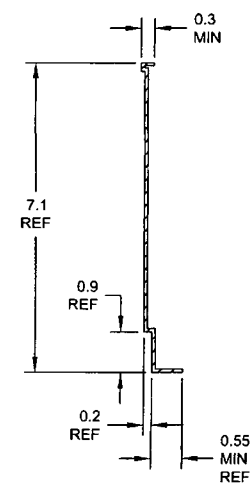
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

RELEASED
09/05/05

u/w 55436

DESIGN	RA	DART AEROSPACE LTD	
DRAWN	RA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RA	DRAWING NO.	REV. C
MFG. APPR.	RA	D3822	SHEET 3 OF 6
APPROVED	RA	TITLE	SCALE
DE APPR.	RA	VERTICAL TUNNEL (BELL 206 A/B)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

B

37.8
REF

0.3
REF

MIN THICKNESS
0.035
(SHADED REGION,
BOTH SIDES)

2.4
REF

VIEW F
A1-4

VIEW J
A3-4

6.7
REF

MIN THICKNESS
0.020
(SHADED REGION)

0.5
MIN

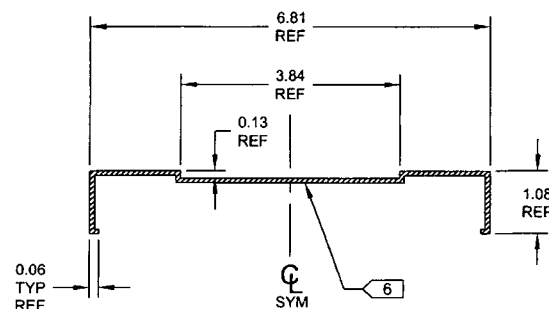
B

E

C2-4

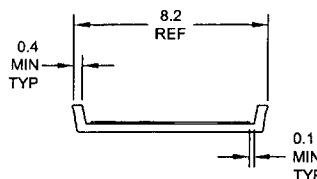
TEXTURED SIDE

CL
SYM



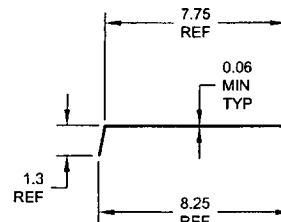
SECTION E-E
SCALE 5X

C6-4



VIEW J
SCALE 2X

D5-4



VIEW F
SCALE 2X

B7-4

(ROTATED 90° CW)

D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	RA	RELEASED <i>09/05/05</i> DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RA	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.05.05	
DRAWING NO. D3822 TITLE VERTICAL TUNNEL (BELL 206 A/B) SCALE NTS		REV. C SHEET 4 OF 6

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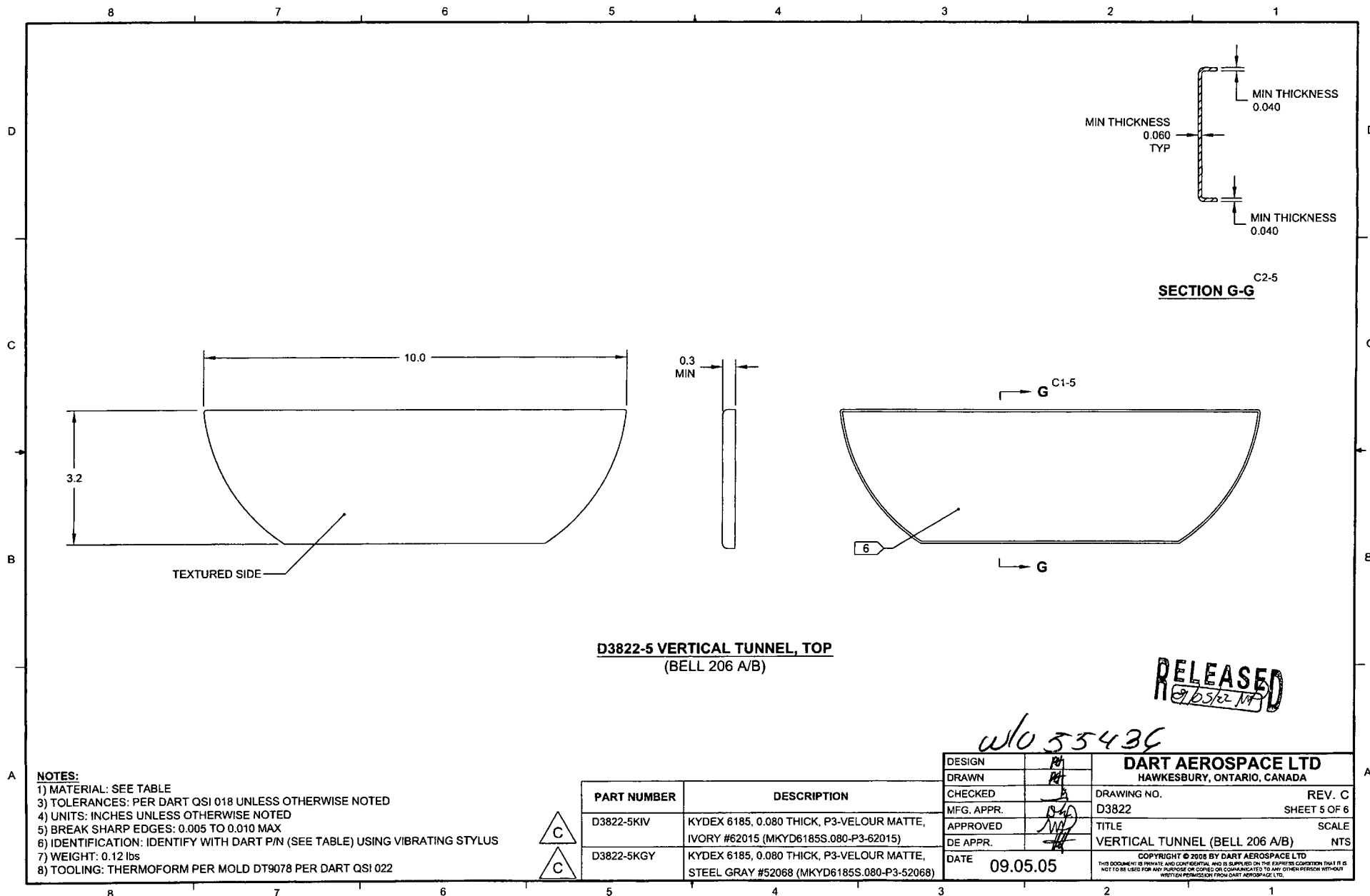
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



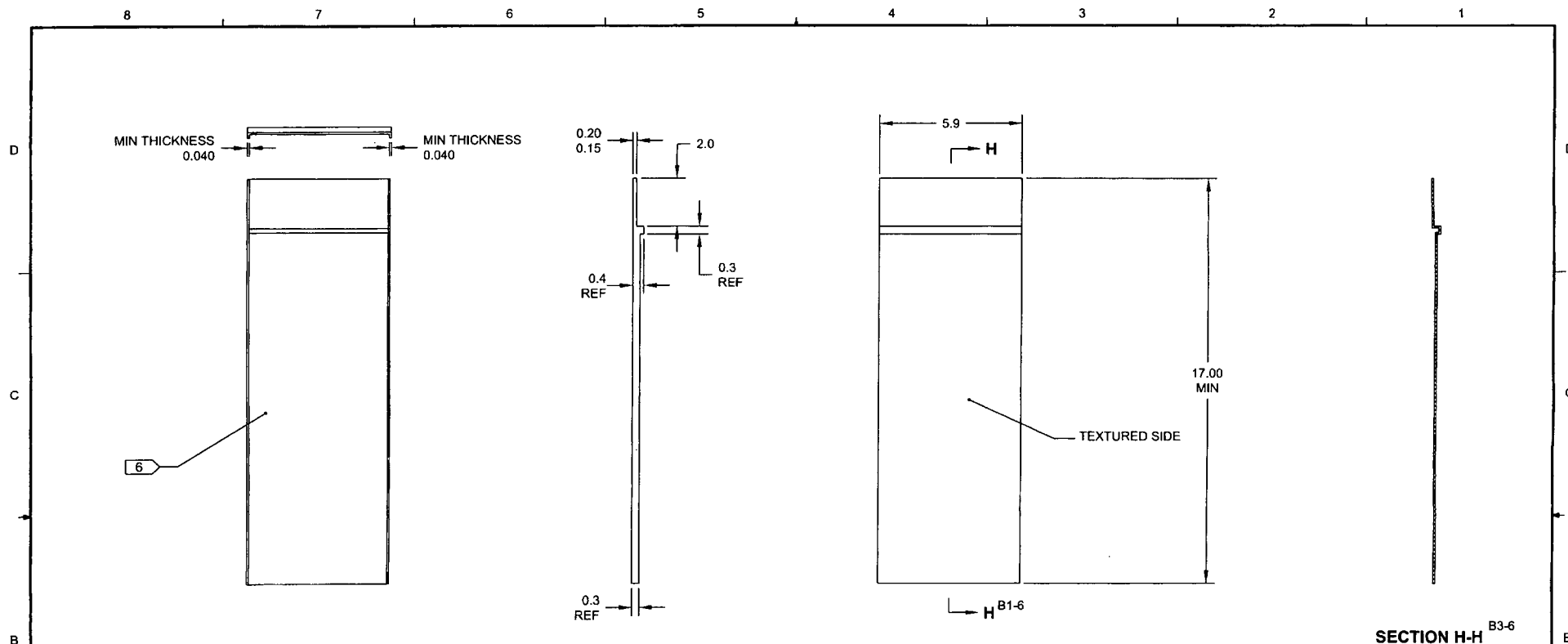
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3822-7 VERTICAL TUNNEL, LOWER
(BELL 206 A/B)

SECTION H-H B3-6

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) WITH VIBRATING STYLUS
- 7) WEIGHT: 0.36 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-7KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-7KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	WLC	DART AEROSPACE LTD
DRAWN	WLC	HAWKESBURY, ONTARIO, CANADA
CHECKED	WLC	DRAWING NO. D3822
MFG. APPR.	WLC	REV. C
APPROVED	WLC	SHEET 6 OF 6
DE APPR.	WLC	SCALE
DATE	09.05.05	TITLE VERTICAL TUNNEL (BELL 206 A/B) NTS
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RELEASED
9/25/22

WLC 55436

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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